

Date: Thursday, 11/29/2007 11:17:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SLUG
Job Number : 36044	
Estimate Number : 10162	
P.O. Number : N/A	Part Number : D2587
This Issue : 11/29/2007 S.O. No. : N/A	Drawing Number : D2587 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 11/29/2007 Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 34307	Material : N/A
Written By : <u>Jim. 11 29</u>	Due Date : 12/6/2007 Qty: 40 Um: Each
Checked & Approved By : <u>Jim. 11 29</u>	
Comment : Est D 04.05.31 Step 2 changed KJ/JLM	
Est E 06.07.31 Waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.6720 sf(s)

6061T6 alum. sheet 0.040" thick

Batch: **102723** **07-12-4**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2587

Dwg Rev: **A1**

Prog Rev: **A1**

07-12-4

(SS)

2-Deburr if necessary

07/12/05

(56)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/12/05 **(56)**

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-12-06

(56)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 21/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:17:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SLUG

Job Number: 36044

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

LS 01/12/07

(56)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5137

LS 01/12/07

(56)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

01/12/07

Job Completion



11/27/02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

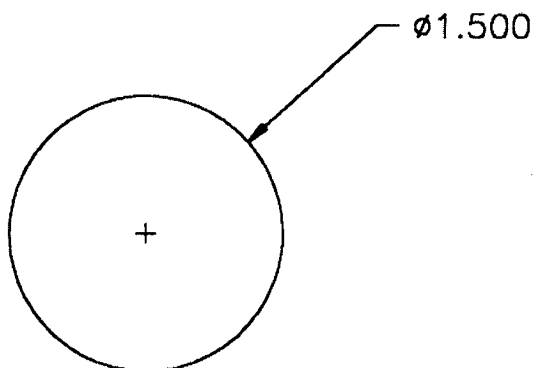
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED	APPROVED	D2587	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:07:11	DOOR SLUG	1:1	
AI 1/2 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 BU



OR 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36044